

Work Order ID .71664

Thursday, July 07, 2011 12:09:03 PM



Page 1

Item ID: D3443-7

Accept



Setup Start



Revision ID:

Item Name: Tubing

Stop



Start Date: 7/7/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 7/21/2011 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan: CL

Date: 11/07/07

Tooling:

Date:

Run Start



QC: _____

Date: _____

SPC (Y/N):

Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3443	Rev C

100 0.00

Brake NC NC BRAKE

Brake NC Memo 0.00

1- Form as per Dwg D3443 using DT811702- Deburr per dwg D3443

SB 11/07/20

(6)

110 0.00

Small Fab Small Fab

Small Fab Memo 0.00

GRIND RAD PER DWG

SF 11/07/21 8

Pto →

120 0.00

QC QC5- Inspect part completeness to step on W/O

Quality Control Memo 0.00

S work

(x9) (x4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3443-7 PAR #: N/A Fault Category: Small Fab. NCR: Yes No DQA: 11 Date: 11.08.17
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: 11 Date: 11.8.19

NCR: 71664		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/08/05	110	Found when inspecting Q5 that the holes were started by at the wrong step and by the wrong depth.	B 08/05	→ Scrap + Destroy Qty +1 hole is off center by 0.30mm	88 11/08/05	S 11/08/05	B 08/05	S 11/08/05
		Causing one part to have the 0.438" hole drilled off center. L.L. loss when reading w/o.		No Repeal				
		(no sig for this due to moral only)						

NOTE: Date & initial all entries

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Start Date: 7/7/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 7/21/2011 Req'd Qty: 8.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



CONVENTIONAL MILLING MACHINE

0.00

*AS 11/08/08**7*

Mill Conv

Memo

0.00

Conventional Milling Machine

1- Mill end to lenght and drill hole as per dwg D3443-2-Deburr as per dwg
D3443

140



QC2- Inspect parts off machine FAI/FAIB

0.00

*AS 11/08/08**7*

Quality Control

Memo

0.00

150



QC8- Inspect parts - second check

0.00

*AS 11/08/08**7*

Quality Control

Memo

0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 71664

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Item ID: D3443-7

Accept



Setup Start



Revision ID:

Item Name: Tubing

Stop



Start Date: 7/7/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 7/21/2011 Req'd Qty: 8.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

160



Packaging

Packaging

Operation
DescriptionIdentify as per dwg & Stock Location: W/ASet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

PL 11-876X7

170



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

025

0.00

11/8/18 JJPLC-08-14
7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, July 07, 2011 12:09:00 PM

Page 1

Work Order ID: 71664



Parent Item: D3443-7



Parent Item Name: Tubing

Start Date: 7/7/2011

Required Date: 7/21/2011

Start Qty: 8.00

Required Qty: 8.00

Comments: A□05.11.14□New issue□EC□

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.750W.120 		Purchased		No		100	f	11.6721	0.75	6.315789 		EJS 1/07/19	

304 ss round tube .750 x .120w

Location	Loc Qty	Loc Code
MAT017	11.67210527	
114706	11.6721053	

6.315789

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD

Work Order: 71664

Description: tubing

Part Number: 3443-7

Inspection Dwg: 3443 Rev: C

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Measured by:

Audited by:

Prototype Approval:

11/08/08

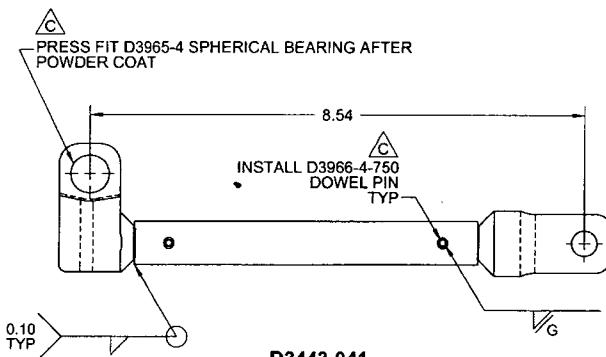
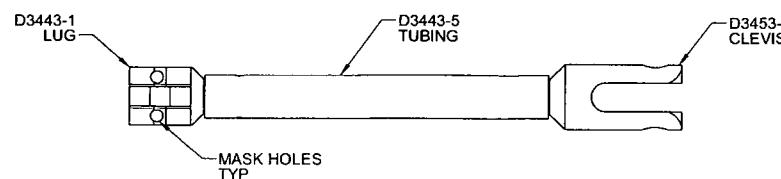
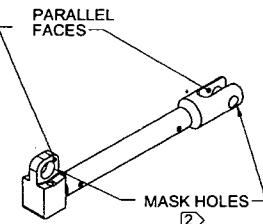
Date:

11/08/08

Date:

Rev	Date	Change	Revised by	Approved
A		New issue	KJ/JLM	

ITEM	QTY	P/N	DESCRIPTION
1	X	D3443-041	STRUT WELDMENT ASSEMBLY
2	1	D3443-1	LUG
3	1	D3443-5	TUBING
4	1	D3453-1	CLEVIS
5	1	D3965-4	BEARING, SPHERICAL
6	2	D3966-4-750	PIN, DOWEL



NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
NO POWDER COAT IN HOLES
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 1.33 lbs
- 8) WELD PER DART QSI 004

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WORK ORDER

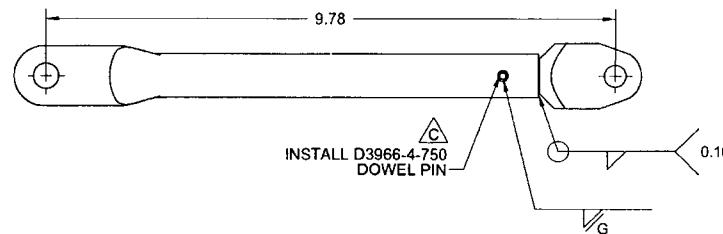
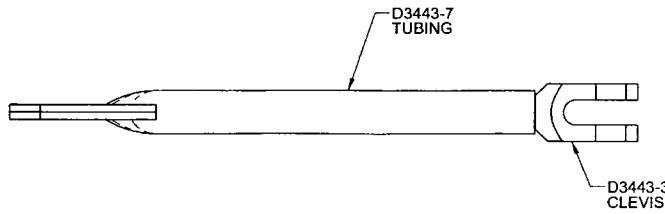
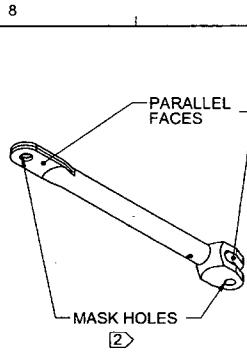
NO. 71669

CL 11/07/07

RELEASED
09/08/2014

C	DRAWING UPDATED TO CURRENT STANDARDS. WAS 1.53 (ZIN C-3); 0.561 WAS 0.561 (ZIN C-3); 0.620 WAS 0.700 & 1.43 WAS 1.53 (ZIN C-3); 0.561 WAS 0.561 (ZIN C-3); 0.620 WAS 0.700 & 1.43 WAS R0.050 (ZIN C-3); D3965-4 WAS SPHERICAL PIN (ZIN C6-1, BS-2); D3966-4-750 WAS McMaster-Carr P/N (ZIN B5-1). REF PAR 09-018	RF	09.06.25
B	ADDED -9 PIN; REMOVED BALL PLUNGER; REVISE TOLERANCE & Ø0.125 WAS #30	RF	05.12.05
A	NEW ISSUE	RF	05.09.02
REV.	DESCRIPTION		
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF	DRAWING NO. D3443	
CHECKED	<i>[Signature]</i>	REV. C SHEET 1 OF 4	
MFG. APPR.	<i>[Signature]</i>	TITLE SCALE	
APPROVED	<i>[Signature]</i>	STRUT WELDMENT ASSEMBLY	
DE APPR.	<i>[Signature]</i>	DATE 09.06.25	

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D3443-043

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
NO POWDER COAT IN HOLES
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.97 lbs
- 8) WELD PER DART QSI 004

ITEM	QTY -043	P/N	DESCRIPTION
1	X	D3443-043	STRUT WELDMENT ASSEMBLY
2	1	D3443-3	CLEVIS
3	1	D3443-7	TUBING
4	1	D3966-4-750	PIN

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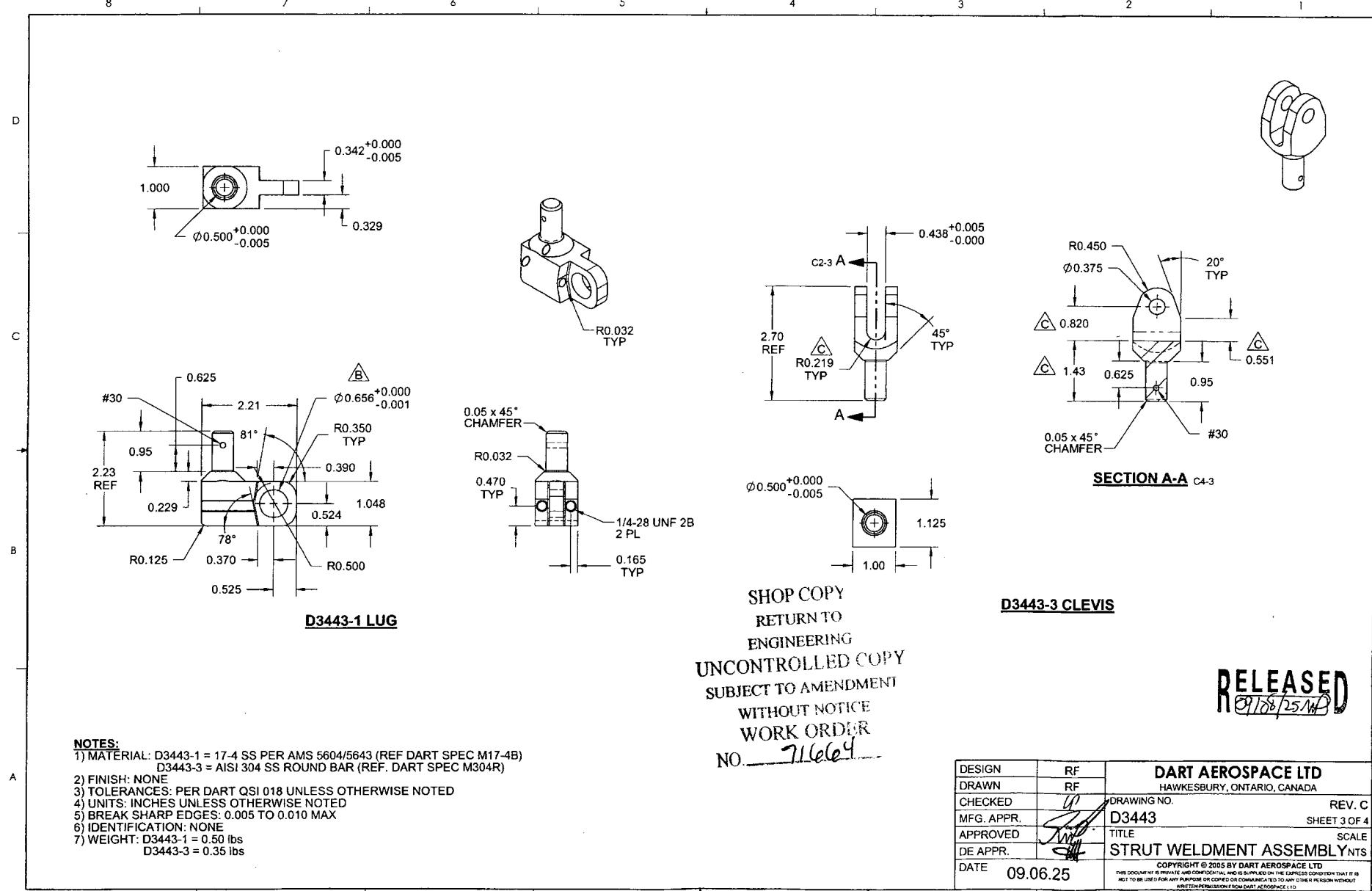
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WORK ORDER

NO. 71664

RELEASED
09/08/25/M

DESIGN	RF	DART AEROSPACE LTD			
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA			
CHECKED	<i>✓</i>	DRAWING NO.			
MFG. APPR.	<i>✓</i>	REV. C			
APPROVED	<i>✓</i>	D3443			
DE APPR.	<i>✓</i>	SHEET 2 OF 4			
DATE	09.06.25	TITLE			
		SCALE			
		STRUT WELDMENT ASSEMBLY			
NTS					
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NOTES:

1) MATERIÁL: D3443-1 = 17-4 SS PER AMS 5604/5643 (REF. DART SPEC M17-4B)
D3443-3 = AISI 304 SS ROUND BAR (REF. DART SPEC M304R)

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT: D3443-1 = 0.50 lbs
D3443-3 = 0.35 lbs

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D3443-3 CLEVIS

RELEASED
09/08/2014

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DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3443	SHEET 3 OF
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	STRUT WELDMENT ASSEMBLY NTS	
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